

Date: Monday, 9/18/2006 2:29:38 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 28639	
Estimate Number : 10299	
P.O. Number : N/A	Part Number : D25775
This Issue : 9/18/2006 S.O. No. : N/A	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 28122	Material : N/A
Written By : <u>JA 06 09 18</u>	Due Date : 10/5/2006
Checked & Approved By : <u>JA 06 09 18</u>	Qty: <u>144</u> Um: Each
Comment : Est: F 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 1.0301 sf(s)/Unit Total: 51.5025 sf(s) 1010/1025 16GA SHEET (m1010s16ga) Batch: <u>M102 372 (46)</u> <u>SAD</u> <u>08:10:14</u> <u>(46)</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 2-Cut's per Dwg D2577 Dwg Rev: <u>E</u> Prog Rev: <u>E</u> 2-Deburr if necessary <u>SAD</u> <u>08:10:14</u> <u>(46)</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1 <u>JA 08 10 23</u> <u>(46)</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>JA 10 25 (46)</u> <u>conv</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>SAD</u> <u>08:11:12</u> <u>(46)</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/18/2006 2:29:38 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28639

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SB 06/11/14 (46)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/14 (46)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

m-h/a.m

06/12/15 (46)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

yl

06/12/21 x 46

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP

yl

06/12/28

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(46)

SB 07/10/02

Job Completion



U 06/12/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
00.09.22

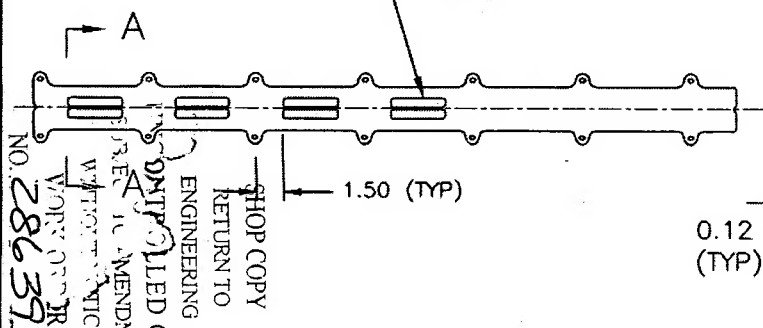
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CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 1 OF 5
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBOUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

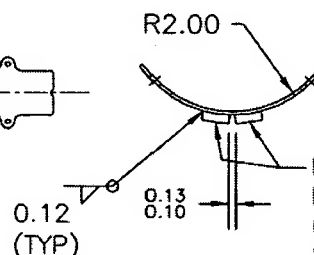


D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5

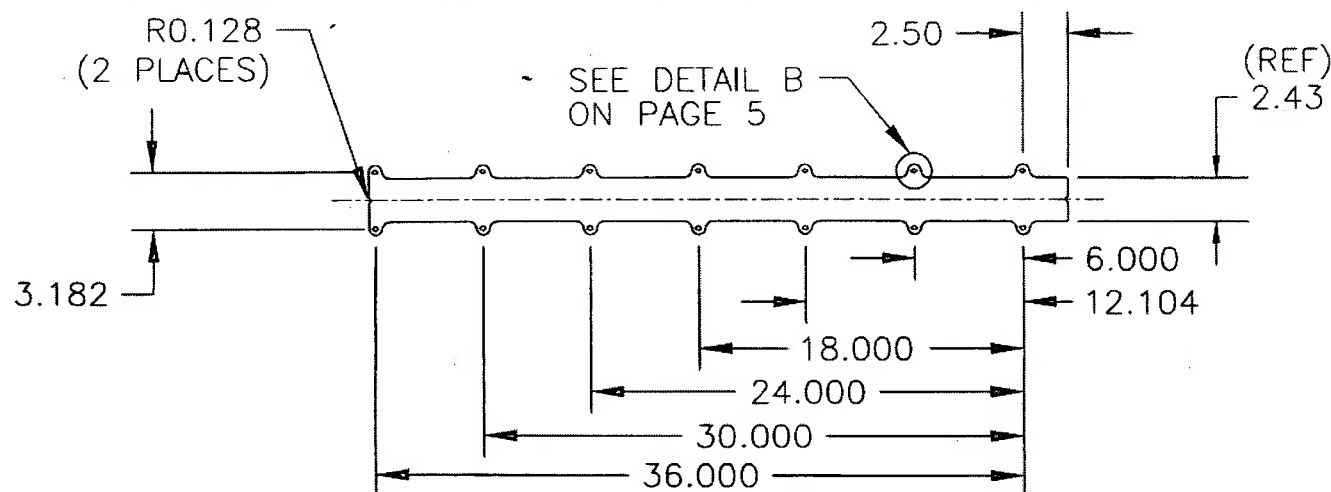


D2941-300 (REF)
REMOVE POWDER
COAT FROM THESE
SURFACES

D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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DATE	DRAWING NO.	REV. E
00.09.22	D2577	SHEET 2 OF 5
	TITLE	SCALE
	WEARSHOE	1:10



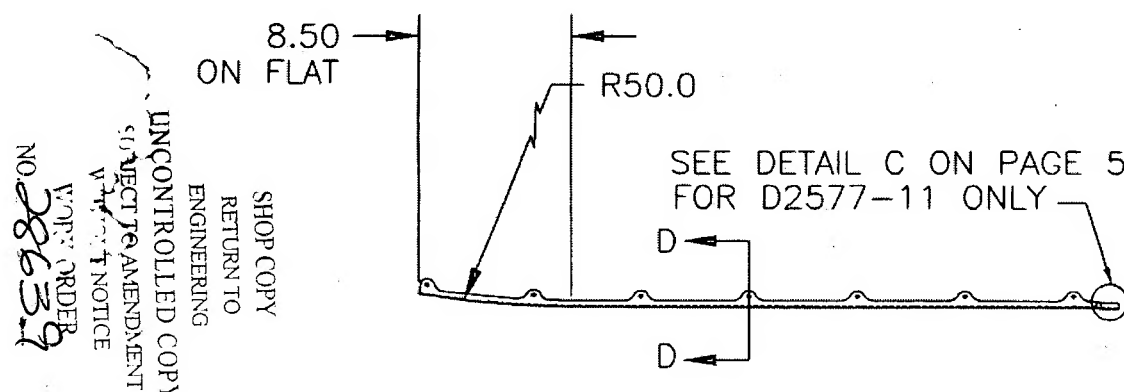
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

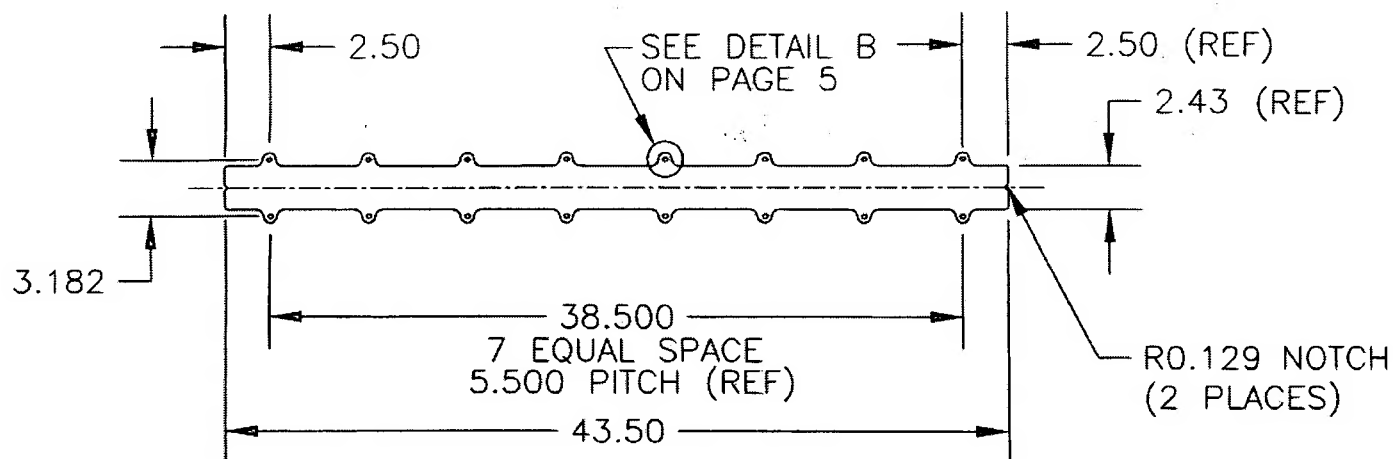
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00.09.26 #



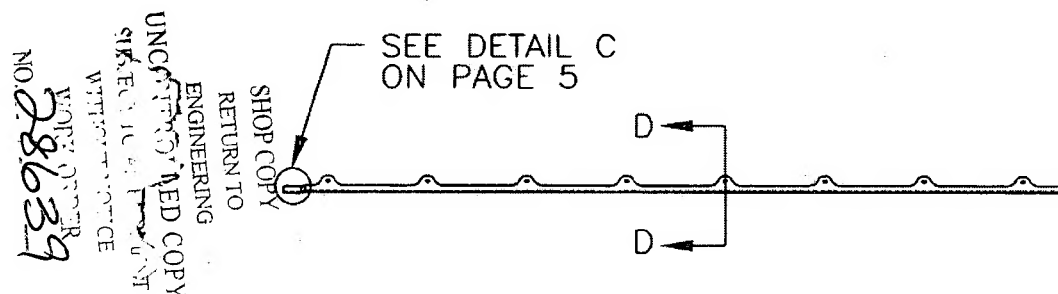
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✓	CP	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D2577
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 3 OF 5
		SCALE 1:10

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00.04.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 28639

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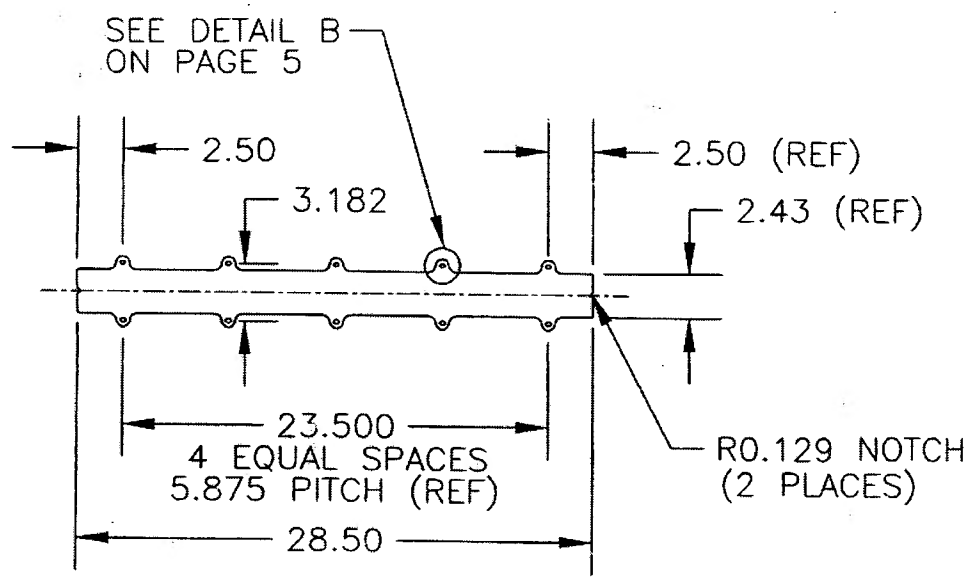
DART



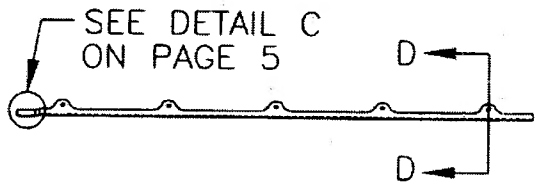
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CHECKED	APPROVED		
DATE	TITLE	DRAWING NO.	SHEET 4 OF 5
00.09.22	WEARSHOE	D2577	SCALE
			1:10

RELEASED
00 09 26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
 SERIES STEEL 0.063 THICK
 FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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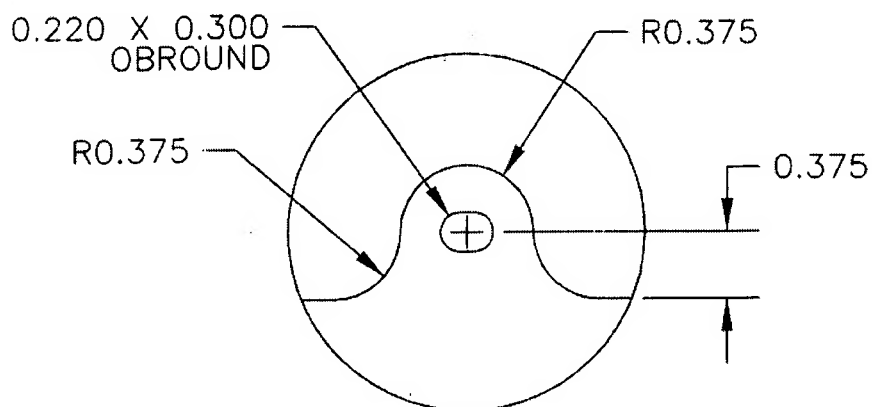
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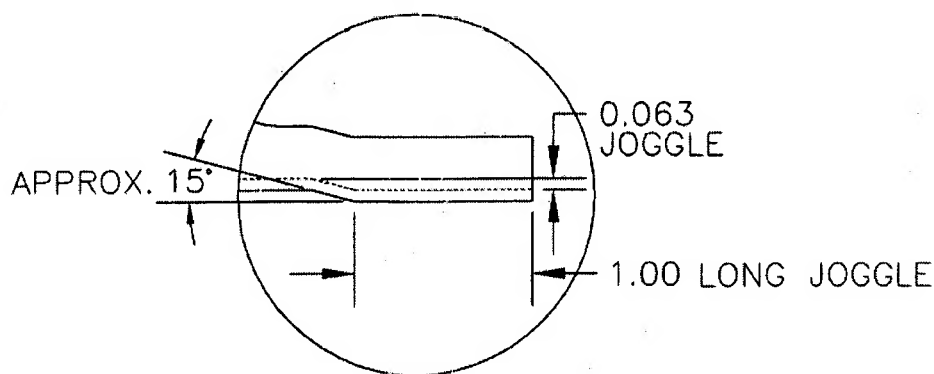
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

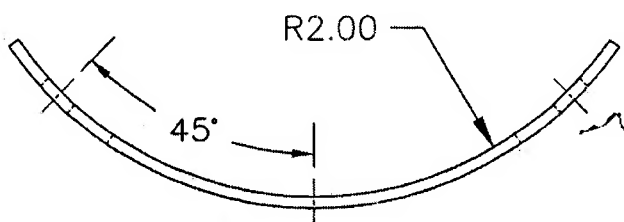
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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